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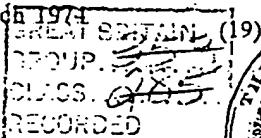
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CLASS 285
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(54) IMPROVEMENTS IN PIPE UNIONS

(71)	PANY LIL	Q67	★A1007Y/01 *GB 1460-864	ction of the
5	Delta Roac hereby dec pray that a the method be particu following s	Mfg. pipe union for incompatible threaded members - by threading tubular member, fitting union nut, screwing end member on and deforming threaded joint	SPEY & CO LTD 14.03.74-G8-011308 (06.01.77) F161-19	method of nd set forth end of the ier member threads, the tubular other end, er to said ermanently int between aid further radially. the further a drop of a applied to
10	This inve providing first and set which the more partic comprising flange and member h: adjacent to being adap with the fir:	A pipe union for two incompatible threaded members is formed from a stamped union nut (1) held captive on a sta- mped and machined tubular member (2) secured to a forged member (3). The nut is tapped and the member (3) has an external tapered thread (6). The union is formed by first forming a thread on one end of the tubular member (2) and then passing the nut over this end. The member (3) is then screwed onto the tubular mem- ber and a ball plunger or roller bur- nishing tool inserted to expand the joint to bind the threads of the joint together to form a gas tight seal. 13. 6. 75 (4pp)	55	
15	20	of the tub member by co-operation between the flanges of the nut and the tubular member on tightening of the union nut onto the first member, and a further metallic member secured to the other end of the tubular member and adapted to screw-threadedly engage with the second screw-threaded member, the union nut being held captive on the tubular member by the flange on the tubular member and said further member which has a sufficiently large transverse dimension to prevent passage of the union nut over said further member.	60	
25	30	Unions of this kind have been used for connecting gas appliances together, for connecting a meter service governor to a meter for example.	65	
35	40	It is known to connect the tubular member to said further member after assembly of the union nut onto the tubular member by screwing and brazing the tubular member to said further member.	70	
45	48	This is, however, an expensive operation, requires testing of the seal between the two members, and has a high reject rate. Moreover the seal between the two members may be broken when the union is	75	
55	60	other end is formed with an external screw thread for engagement with a co-operating internal screw thread formed in said further member.	80	
65	70	Usually the further member will be formed with an external radially extending polygonal flange for engagement by a spanner when the further member is tightened in use to the second member. It is this polygonal flange which would prevent assembly of the union nut onto the tubular member if the tubular member were to be made integral with the further member.	85	
75	80	The tubular member and the further member may be made of any suitable metal but preferably they are made of brass.	90	
85	90	The expansion of the joint between the tubular member and the further member is conveniently performed by cold forming with a ball plunger or roller burnishing tool.	95	
95	98	The invention will now be further described, by way of example only, with reference to the accompanying drawing which is an axial cross section of a com- pleted brass union adapted to secure an externally screw-threaded first member to an internally screw-threaded second member to provide fluid communication therebetween.	100	

The union comprises a stamped union nut 1 held captive on a stamped and machined tubular member 2 secured to a further member 3 which is a forging.

5 The union nut 1 is internally screw-threaded for engagement with external screw threads on a first member, not shown, and is provided with an internal radial flange 4 for engagement with an external radial flange 5 which is an integral part of one end of the tubular member 2. When the union nut 1 is screwed in use onto the first member the tubular member 2 is drawn towards the first member by the engagement between 10 the flanges 4 and 5.

15 The further member 3 is formed with an external tapered screw thread 6 for engagement with an internal co-operating screw thread of a second member, not shown, and is provided with an integral polygonal radial flange 7 for engagement by a spanner during tightening in use of the further member 7 to the second member.

Initially the other end 8 of the tubular 20 member 3 comprises a plain sleeve. Prior to assembly of the union nut 1 onto the sleeve the exterior of said other end 8 is formed with a plain external screw thread for engagement with a complementary screw 25 thread formed internally of the further member 3. The union nut is then assembled onto the tubular member 2 by passing it over said other end 8 of the tubular member. The tubular member and the further member are 30 then screwed together and a ball plunger or roller burnishing tool is inserted into the joint between the members by passing it through the further member 3, and the joint between the members is expanded radially 35 over the distance A by cold forming to increase the internal diameter D of the joint and to bind the screw threads of the joint together to form a gas-tight seal between the tubular member 2 and the further member 40

45 3. In one example the initial diameter D is 0.875 inches and a plunging tool of 0.925" diameter is used. The diameter D is thus increased by slightly more than 4% of its initial value.

50 In order to increase the break-loose torque of the joint between the members 2 and 3 a drop of a screw-thread locking material such as that sold under the 55 Registered Trade Mark 'LOCTITE' STUDLOCK (OR GRADE 75) is applied to the middle part of one of the screw threads before the members 2 and 3 are screwed together.

WHAT WE CLAIM IS:—

1. A method of manufacturing a pipe union of the kind set forth comprising forming said other end of the tubular member and said further member with complementary screw threads, assembling the union nut onto the tubular member by passing it over said other end of the tubular members, screwing said tubular member to said further member, and then permanently deforming the screw-threaded joint between said tubular member and said further member by expanding the joint radially. 60

2. The method according to claim 1 in which the tubular member is formed with its screw thread prior to assembling the union nut onto the tubular member. 65

3. The method according to claim 1 or claim 2 in which prior to screwing the tubular member to said further member screw-thread locking material is applied to at least one of the co-operating screw threads. 70

4. The method according to any of the preceding claims in which the co-operating screw threads comprise an external screw thread formed on the tubular member and an internal screw thread formed on said further member. 75

5. The method according to any of the preceding claims in which the expansion of the joint is performed by cold forming. 80

6. The method according to claim 5 in which the joint between the tubular member is expanded by insertion of a ball plunger. 85

7. The method according to claim 5 in which the joint between the tubular member is expanded by a roller burnishing tool. 90

8. The method according to any of the preceding claims in which the tubular member and said further member are of brass. 95

9. The method according to any of the preceding claims in which the internal diameter of the joint between the tubular member and said further member is increased by more than four per cent of the initial diameter. 100

10. The method according to claim 1 and substantially as described with reference to the accompanying drawing. 105

11. A pipe union of the kind set forth produced by the method according to any of the preceding claims. 110

12. A pipe union of the kind set forth manufactured according to the method of claim 10 and substantially as described with reference to the accompanying drawing. 115

	WHAT WE CLAIM IS:—	
5	1. A method of manufacturing a pipe union of the kind set forth comprising forming said other end of the tubular member and said further member with complementary screw threads, assembling the union nut onto the tubular member by passing it over said other end of the tubular members, screwing said tubular member to said further member, and then permanently deforming the screw-threaded joint between said tubular member and said further member by expanding the joint radially.	60
10	2. The method according to claim 1 in which the tubular member is formed with its screw thread prior to assembling the union nut onto the tubular member.	65
15	3. The method according to claim 1 or claim 2 in which prior to screwing the tubular member to said further member screw-thread locking material is applied to at least one of the co-operating screw threads.	70
20	4. The method according to any of the preceding claims in which the co-operating screw threads comprise an external screw thread formed on the tubular member and an internal screw thread formed on said further member.	75
25	5. The method according to any of the preceding claims in which the expansion of the joint is performed by cold forming.	80
30	6. The method according to claim 5 in which the joint between the tubular member is expanded by insertion of a ball plunger.	85
35	7. The method according to claim 5 in which the joint between the tubular member is expanded by a roller burnishing tool.	90
40	8. The method according to any of the preceding claims in which the tubular member and said further member are of brass.	95
45	9. The method according to any of the preceding claims in which the internal diameter of the joint between the tubular member and said further member is increased by more than four per cent of the initial diameter.	100
50	10. The method according to claim 1 and substantially as described with reference to the accompanying drawing.	105
55	11. A pipe union of the kind set forth produced by the method according to any of the preceding claims.	110
	12. A pipe union of the kind set forth manufactured according to the method of claim 10 and substantially as described with reference to the accompanying drawing.	115

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